

729-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:37:03 AM  
 User: Julie Dawson

## Process Sheet



<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GHW MEDIUM BELL
<b>Job Number</b> : 47359A	
<b>Estimate Number</b> : 12129	
<b>P.O. Number</b> :	<b>Part Number</b> : D412729041
<b>This Issue</b> : 22/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : DSK 092 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 22/04/2009 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 47358A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.22</u>	
<b>Comment</b> : Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

N/A

2.0	D27287	Dart Logo label
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**Comment:** Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Label	B 22554

9/5/4

SP

3.0	D3233041	Wheel Assembly
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3233-041	Wheel Assembly	B 45169

47494 x1.

B 45169 → 21

9/5/4

SP

4.0	D32331	Inside Washer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3233-1	Inside Washer	43625

9/5/4

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: GHW MEDIUM BELL

Job Number: 47359A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32333

Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer

45170

9/5/4

sd

6.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label

43659

9/5/4

sd

7.0

D33093

Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label

45173

9/5/4

sd

8.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment

45174

9/5/4

sd

9.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly

B37082

9/5/4

sd

W/O:		WORK ORDER CHANGES					
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Job Number: 47359A

Part Number: D412729041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D3332041	Pin Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly 44202

9/5/4

SP

11.0	D3332043	Pin Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly 41364

9/5/4

SP

12.0	D33331	Base Plate Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate 45081

9/5/4

SP

13.0	D33333	Sliding Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate 46254

9/5/4

SP

14.0	D33335	Rail
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail 45083

9/5/4

SP

(2k)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Drawing Name: GHW MEDIUM BELL

Job Number: 47359A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B46043

9/5/4

SP

16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring 47513

9/5/4

SP

17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring 45180

9/5/4

SP

18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B43352-722x

25/09/05/04

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M110363

9/5/4

SP

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span

M1108200

9/5/4

SP

21.0 HC12 1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

N/A

22.0 HC29 5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M110611

14 18  
M110684  
9/5/2

SP

23.0 HC153 3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span

M110611

9/5/4

SP

24.0 HN120 HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof

M1102150

9/5/4

SP

Qty ① D3015-1 LOCK-NUT B14710-22x

09/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47359A

Part Number: D412729041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	HN177	5/16-18UNC Nylon LockNut
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span

M107031

9/5/4

SP

26.0	HX15	1/4-20 UNCx3/4 S.H.C.S.
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M108300

9/5/4

SP

27.0	MS21042L5	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

M109840

9/5/4

SP

28.0	2333	1 1/4" Type B Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

M1102150

9/5/4

SP

29.0	18SNB	3/8" Lock Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M110611

9/5/4

SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M110611

9/5/4

SP

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof ~~M103165~~

M103165

9/5/4

SP

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

09/05/05

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/05 (+2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

47359

9/5/5

20

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/11

Job Completion



MF 09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

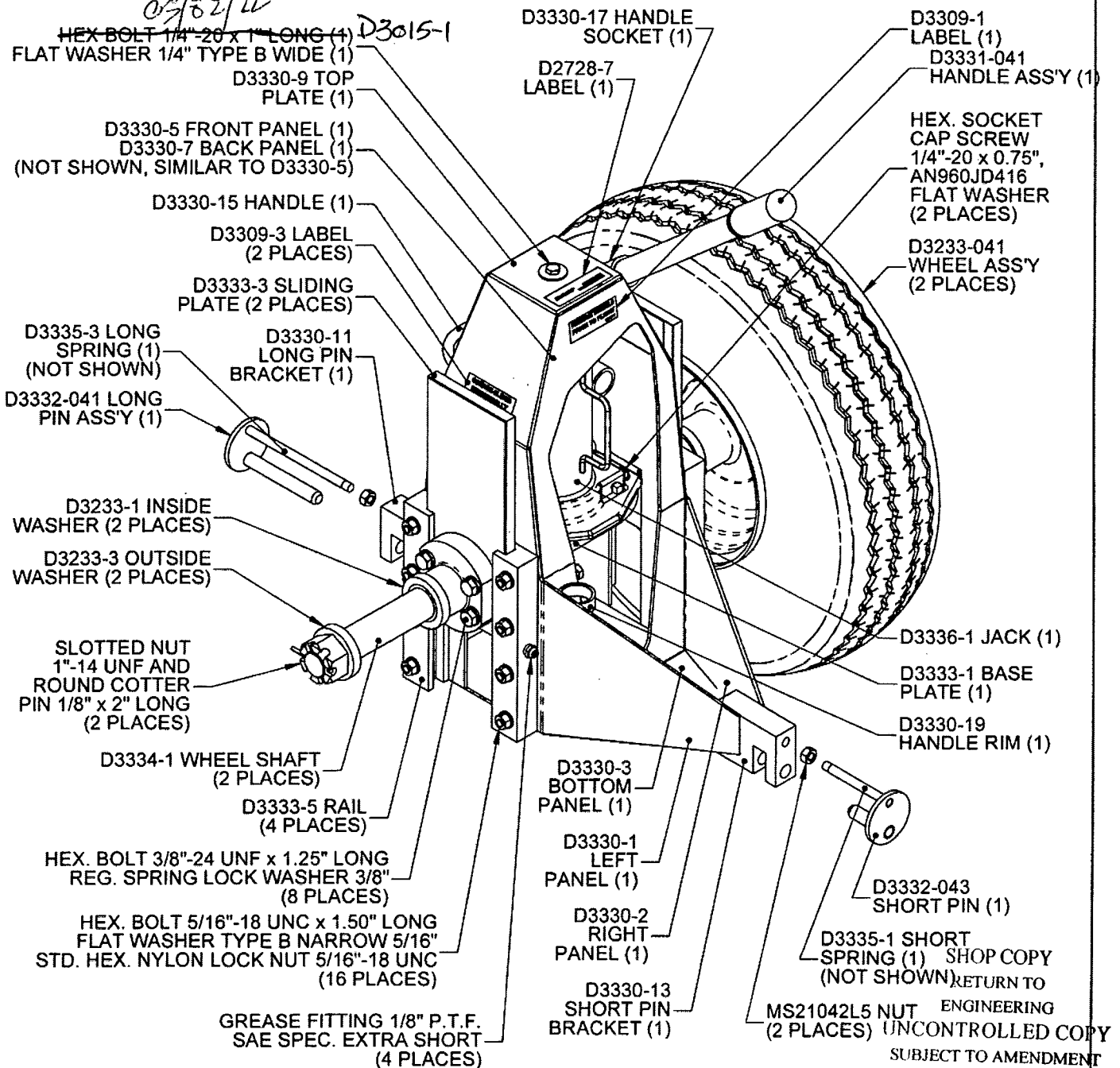
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART****RELEASED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>DSK 092</b>	REV. B SHEET 1 OF 1
DATE <b>05.02.18</b>		TITLE <b>HYD. GROUND HANDLING</b>	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASSY	

**NOTE:**

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

WORK ORDER NO. 403521  
SUBJECT TO AMENDMENT WITHOUT NOTICE  
ENGINEERING UNCONTROLLED COPY

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